



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3884-1

Job Sheet 168604



Part No: D3884-1

Job Qty: 4 ea

Part Name: Saddle, Inside LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/27/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/24/17	11/24/17	0.00	0.00	Start Up Machining		FR 17-11-20
100	CNC Vertical Machining	4 pcs	11/25/17	11/25/17	0.50	7.27	HAAS 1		SBL 17/11/21
110	QC	4 pcs	11/25/17	11/25/17	0.00	0.00	QC2		SBL 17/11/21
120	QC	4 pcs	11/25/17	11/25/17	0.00	0.00	QC8		17/11/21
130	HandFinish	4 pcs	11/25/17	11/25/17	0.00	0.23	HandFinish1		2017-11-22 JSC
140	Powdercoat	4 pcs	11/27/17	11/27/17	0.00	0.17	Powdercoat1		OK 17-11-22
150	QC	4 pcs	11/27/17	11/27/17	0.00	0.00	QC3		NOV-23-2017
160	Packaging	4 pcs	11/27/17	11/27/17	0.00	0.00	Packaging3	ST404	NOV-23-2017
170	QC21-SA	4 Ea	11/27/17	11/27/17	0.00	0.00	QC21		NOV-23-2017

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA818
and inspect per Dimension Sheets
110 - Inspect on CMM as per folio CMM004.
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M 1384167 START 1:15 O.V.T. 320° FINISH 1:45

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-017	4	22	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Inboard, LH	2.870Inches + 0.010 - 0.000	2.880 2.870		
2	Saddle, Inboard, LH	1.433Inches + 0.010 - 0.000	1.443 1.433		
3	Saddle, Inboard, LH	0.638Inches + 0.020 - 0.000	0.658 0.638		
4	Saddle, Inboard, LH	3.895Inches + 0.010 - 0.000	3.905 3.895		
5	Saddle, Inboard, LH	0.257Inches + 0.005 - 0.000	0.262 0.257		
6	Saddle, Inboard, LH	0.605Inches	0.625		



S011662



Saddle, Inside LH

PART NO:
Revision:
Operation:
Change No:

D3884 - 1

Start up Operation

Mfg Date: 11/20/17
Job No: 168604

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

			+ 0.020 - 0.000	0.605
7	Saddle, Inboard, LH	1.120Inches	+ 0.010 - 0.000	1.130 1.120
8	Saddle, Inboard, LH	2.245Inches	+ 0.010 - 0.000	2.255 2.245
9	Saddle, Inboard, LH	2.000Inches	+ 0.020 - 0.000	2.020 2.000
10	Saddle, Inboard, LH	0.140Inches	+ 0.035 - 0.000	0.175 0.140
11	Saddle, Inboard, LH	1.265Inches	+ 0.020 - 0.000	1.285 1.265
12	Saddle, Inboard, LH	0.115Inches	+ 0.020 - 0.000	0.135 0.115
13	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
14	Saddle, Inboard, LH	0.110Inches	+ 0.030 - 0.000	0.140 0.110
15	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
16	Saddle, Inboard, LH	2.826Inches	+ 0.060 - 0.000	2.886 2.826
17	Saddle, Inboard, LH	0.178Inches	+ 0.020 - 0.000	0.198 0.178
18	Saddle, Inboard, LH	0.140Inches	+ 0.025 - 0.000	0.165 0.140
19	Saddle, Inboard, LH	0.720Inches	+ 0.060 - 0.000	0.780 0.720
20	Saddle, Inboard, LH	1.220Inches	+ 0.060 - 0.000	1.280 1.220
21	Saddle, Inboard, LH	1.245Inches	+ 0.010 - 0.000	1.255 1.245
22	Saddle, Inboard, LH	5.990Inches	+ 0.020 - 0.000	6.010 5.990
23	Saddle, Inboard, LH	2.495Inches	+ 0.010 - 0.000	2.505 2.495
24	Saddle, Inboard, LH	0.490Inches	+ 0.020 - 0.000	0.510 0.490
25	Saddle, Inboard, LH	0.020Inches	+ 0.020 - 0.000	0.040 0.020
26	Saddle, Inboard, LH	0.313Inches	+ 0.005 - 0.000	0.318 0.313
27	Saddle, Inboard, LH	0.760Inches	+ 0.005 - 0.000	0.765 0.760
28	Saddle, Inboard, LH	0.215Inches	+ 0.005 - 0.000	0.220 0.215
29	Saddle, Inboard, LH	0.316Inches	+ 0.005 - 0.000	0.321 0.316
30	Saddle, Inboard, LH	1.745Inches	+ 0.010 - 0.000	1.755 1.745
31	Saddle, Inboard, LH	0.990Inches	+ 0.020 - 0.000	1.010 0.990

Plex 11/20/17 8:31 AM dart.lacelle.linda

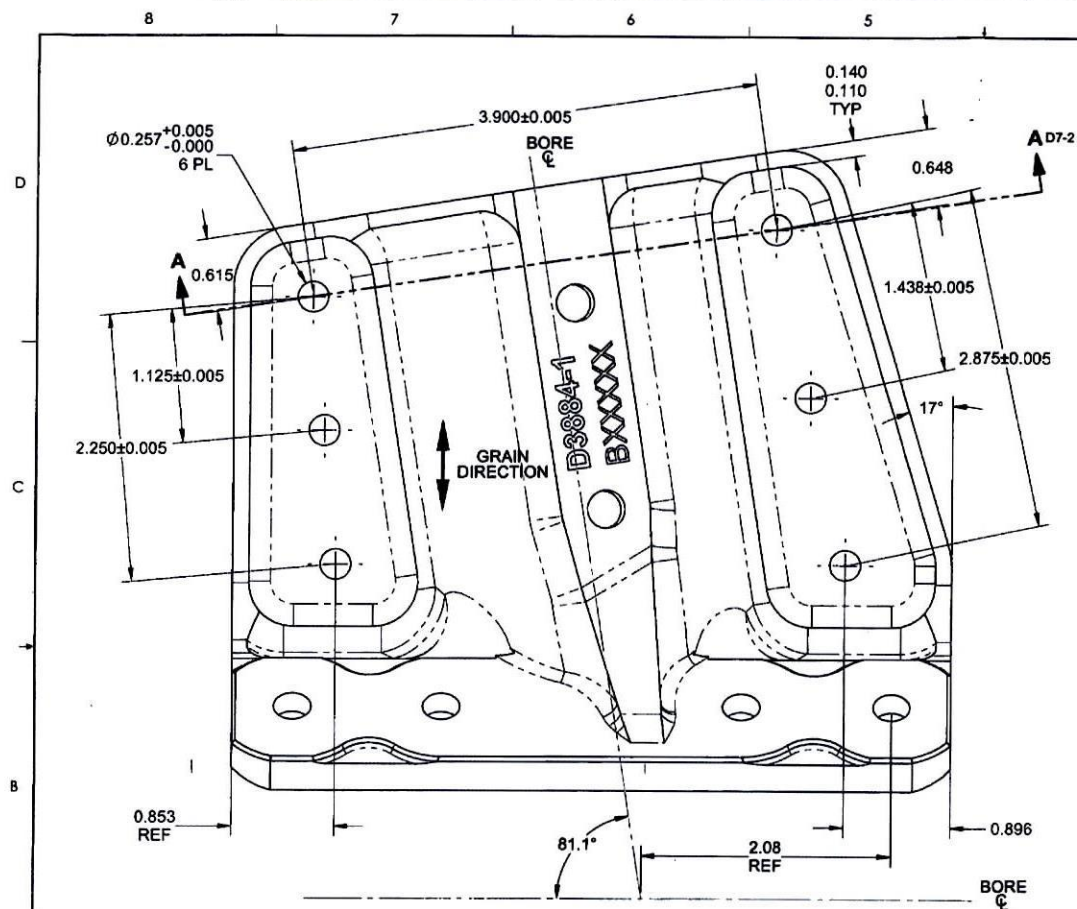
DART AEROSPACE LTD		Work Order: 168604
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2,875	2,875	2,875	2,875		
B	1.433	1.443		1,438	1,438	1,438	1,438		
C	0.638	0.658		1,648	1,648	1,648	1,648		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		258	258	258	258		
F	0.605	0.625		615	615	615	615		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,003	2,002	2,003		
J	0.140	0.175		152	153	152	152		
K	1.265	1.285		1,267	1,270	1,269	1,270		
L	0.115	0.135		125	125	125	125		
M	0.240	0.260		250	250	250	250		
N	0.110	0.140		135	135	136	136		
O	0.240	0.260		250	252	252	252		
P	2.826	2.886		2,850	2,858	2,850	2,855		
Q	0.178	0.198		188	188	188	188		
R	0.140	0.165		150	152	150	150		
S	0.720	0.780		765	755	755	760		
T	1.220	1.280		1,255	1,255	1,253	1,255		
U	1.245	1.255		1,250	1,250	1,250	1,250		
V	5.990	6.010		6,000	6,000	6,000	6,000		
W	2.495	2.505		2,500	2,500	2,500	2,500		
X	0.490	0.510		495	500	500	500		
Y	0.020	0.040		030	030	030	030		
Z	0.313	0.318		313	313	313	313		
AA	0.760	0.765		761	761	761	761		
AB	0.215	0.220		217	217	217	217		
AC	0.316	0.321		316	316	316	316		
AD	1.745	1.755		1,750	1,750	1,750	1,750		
AE	0.990	1.010		998	1,000	1,000	1,000		
AF									
Accept/Reject									

Measured by: SBL	Audited by: 33
Date: 17/11/21	Date: 17/11/21

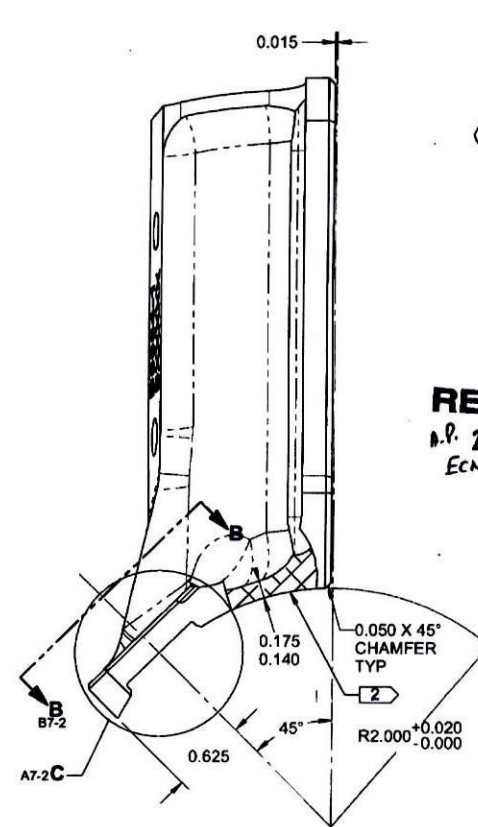
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	



D3884-1 SADDLE, INBOARD LH

NOTES:

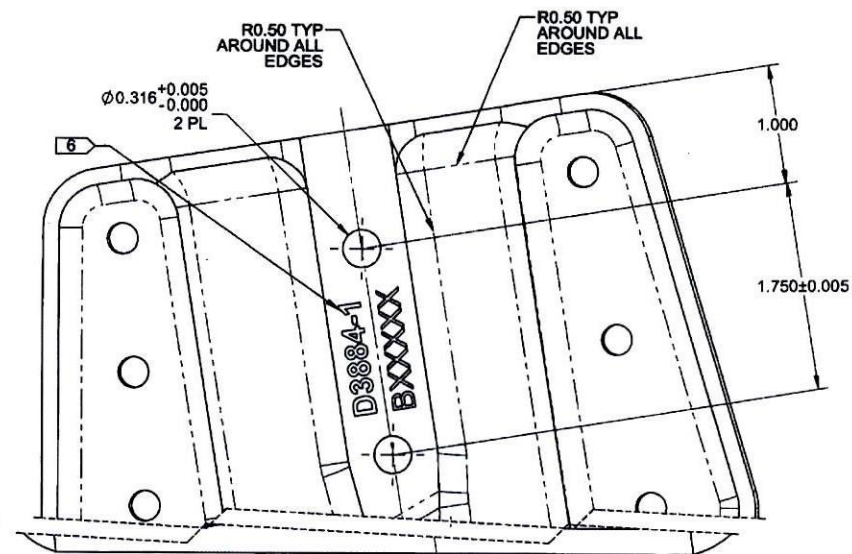
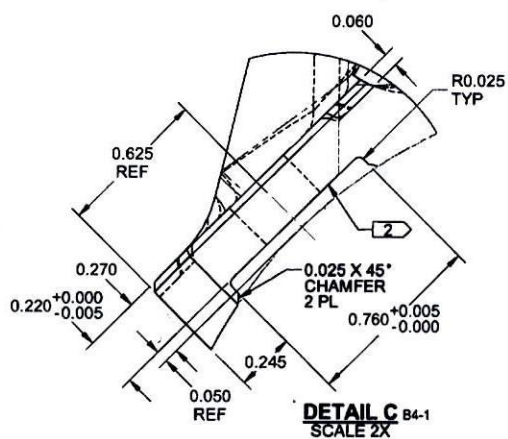
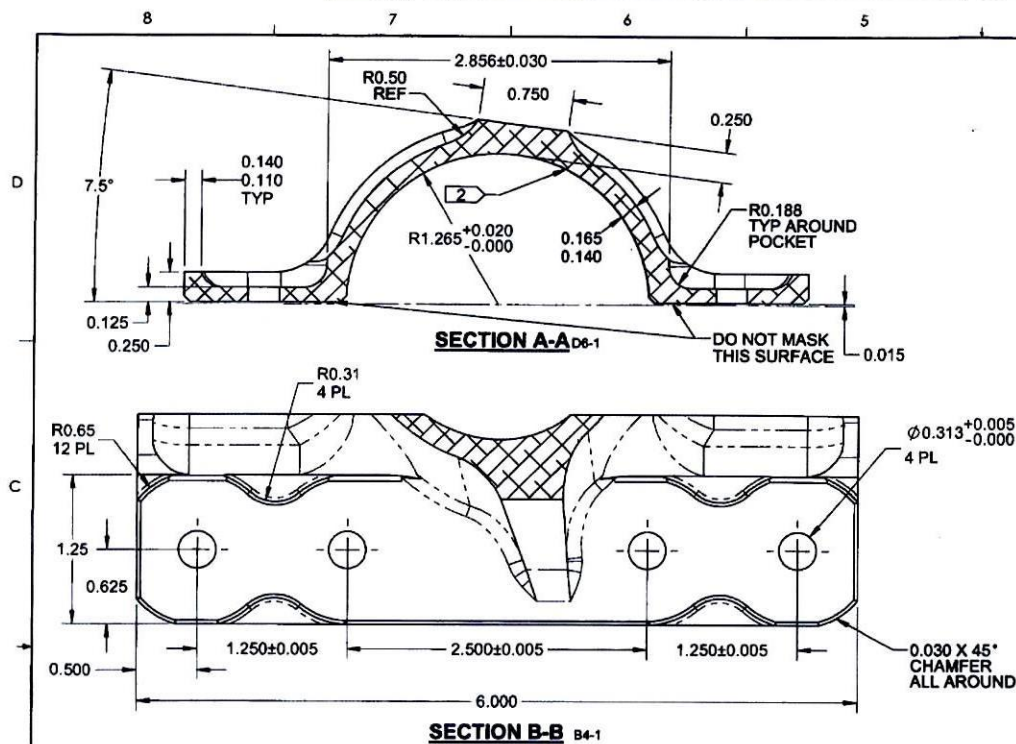
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPRT"



RELEASED
R.P. 2015 MAY 19
ECN15-575

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS. ADDED NOTE 8, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1-2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.185 ZN B7-1; ADD 0.815 ZN C8-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.060 ZN C2-2; 0.75 WAS 0.65 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3884	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	INBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



D3884-1 SADDLE, INBOARD LH (AUXILIARY VIEW)

RELEASED
A.R. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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